

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2015-63 Date Opened: 03-Jun-15 Title: Component

Aircraft OEM: Multiple Aircraft Model: Multiple Product Type: Lid Prop Product Model: N/A Quantity: 15

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JR
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JR
Parts Distribution Sheet	JR
Sub Component Tags	N/A
Completed Certification	N/A
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	JR
Dual Inspections Initialled	JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
36280	3	Lid Brace Assembly	JR

Component Completion

	As Instructed
Quantity Complete on This Work Order	15
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	JR

Certification

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Tracking (White) Tag Completed	JR
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JR
Research and Development	N/A
Third Party	N/A

Traveller

Initial or N/A

Work performed by:

Print: Jason Rekve

Sign: Jason Rekve

SCA: AD01

Date: 05-Jun-15

ICC / Dual Inspection preformed by:

Print: Jeff Clarke

Sign: Jeff Clarke

SCA: AD02

Date: 05-Jun-15

Work Order closed by:

Print: Jason Rekve

Sign: Jason Rekve

SCA: AD01

Date: 05-Jun-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

Date Opened: 03 June 2015

*Approval Information:*Approval: **Multiple** Document Control List: Multiple

Approval on AML: Y / N DCL meets/exceeds revision on STC: Y / N

Part Information:

Fabrication Drawing: 36280 Rev. 3

Matches DCL: Y / N

Qty	Part Number	Description	Material	PO
	9-2081	Slider Assembly		15026
. 1	AN3-4A	Bolt		13017
. 3	NAS1149FO363P	Washer		14048
. 1	NAS1149FO332P	Washer		14048
. 1	MS21044N3	Nut		13084

Processes

☐ Painting☐ Powder Coating☐ Anodizing

PO

Tests/Inspections specified on drawings? Y / N

Test/Inspections complete? Initial: _____

Final Inspection Initial: _____

Work Order pre-completion Inspection:

Release tags required? Y / N (Release tags are not required if part can only used as part of a further assembly)

Release tags complete? Y / N Interim tracking tags complete: Y / N

List all non-conformities raised: _____

Inspector Signature: 

Date: 5 Jun 15

This form is intended for batch production of component parts only.

COMPONENT – LID PROP ASSEMBLY

General

These instructions apply to all cargo basket lid prop assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 36280, Rev. 2

Work Order: 2015-63

Complete
(initial or SCA #)

Date Open: 03-Jun-15

dk

1. Machining

- a. Stock part: 9-2081 brace. Disassemble by sliding apart into separate pieces.
- b. Drill $\frac{1}{4}$ " hole up to $\frac{3}{8}$ " in both parts of slider assembly on drill press. Deburr holes.
- c. Drill #9 hole in 36280-03 slider (outside) in accordance with drawing.
 - i. Locate with stops on manual milling machine.
- d. Mill $\frac{3}{16}$ " slot 36280-02 slider (inside) in accordance with drawing.
 - i. Locate with stops on manual milling machine

dk

2. Assembly

- a. Insert AN3-4A bolt with three (3) NAS1149F0363P washers into hole in 36280-03 slider. Locate head and washer on INSIDE of slider.
- b. Locate one (1) NAS1149F0332P washer on bolt. Thread MS21044N3 nut on bolt, torque to 12-15 in-lbs. Align bolt head with flats ACROSS slider.
- c. Slide 36280-02 slider (inside) into 36280-03 slider (outside). Ensure stop catch inside slider catches on bolt head.
 - i. If inside slider cannot move past bolt, replace one NAS1149F0363P washer with NAS1149F0332P washer under bolt head and reassemble.
 - ii. If inside slider does not catch on bolt, add one NAS1149F0363P washer under bolt head and reassemble.

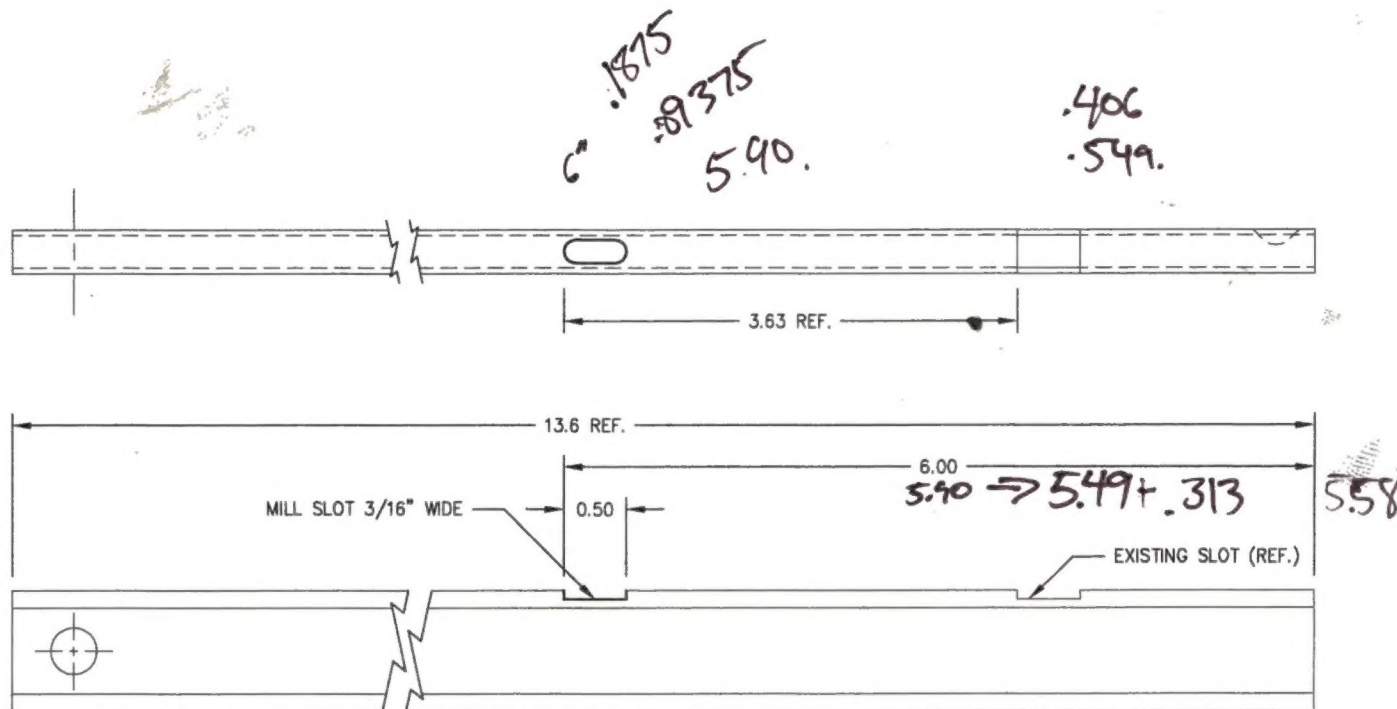
3. Final Inspection

To be completed by a different person than the previous steps.

- a. Tag complete and inspected parts in preparation for installation.

jc

590 → 5.587



02 MODIFIED SLIDER

REMOVE FROM GUIDE TO PERFORM MODIFICATION

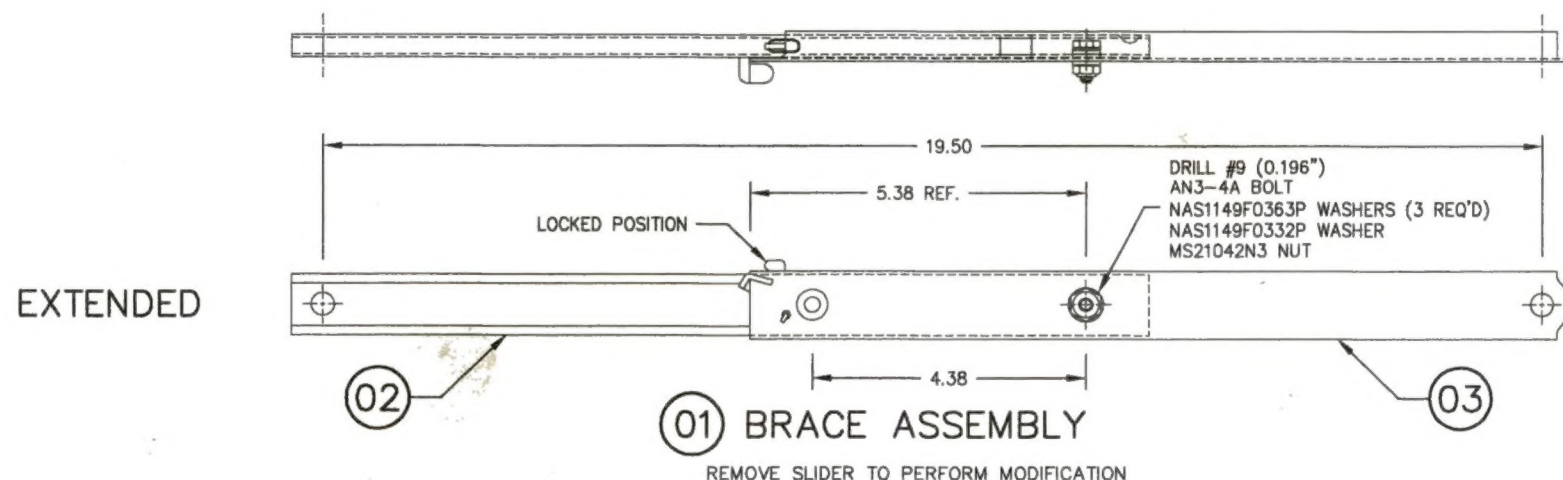
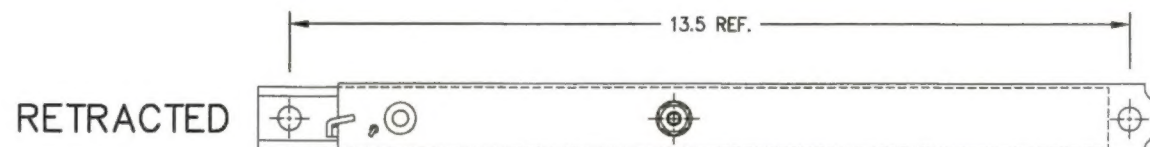
1	9-2081		LID BRACE	VICTORIA BRITISH
	36280-02	02	MODIFIED SLIDER	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			


APPROVALS	DATE	 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.2376 www.aerodesign.ca		
DRAWN: STEVEN FAHEY	MAR 18/02			
CHECKED: E. BURGON	MAY 01/03			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		HELICOPTER CARGO BASKET LID BRACE SLIDER MODIFICATION		
SCALE 1 : 2		DWG. SIZE	DWG. NO.	REV.
SHEET 2 OF 2		A3	36280	3

2015-63

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED POSITION OF STOP BOLT (WAS 4.38")	STF	JUL 01/02
2	CHANGED POSITION OF STOP BOLT (WAS 4.31")	BJC	APR 28/04
3	TITLE BLOCK UPDATED; COMPONENT PARTS IDENTIFIED	BJC	13/03/2014



				APPROVALS		DATE		 <div>AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.2376 www.aerodesign.ca</div>									
				DRAWN: STEVEN FAHEY		MAR 18/02											
				CHECKED: E. BURGOIN		MAY 01/03											
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				<div>HELICOPTER CARGO BASKET LID BRACE ASSEMBLY</div> <table><tr><td>SCALE 1 : 2</td><td>DWG. SIZE</td><td>DWG. NO.</td><td>REV.</td></tr><tr><td>SHEET 1 OF 2</td><td>A3</td><td>36280</td><td>3</td></tr></table>		SCALE 1 : 2	DWG. SIZE	DWG. NO.	REV.	SHEET 1 OF 2	A3	36280	3
SCALE 1 : 2	DWG. SIZE	DWG. NO.	REV.														
SHEET 1 OF 2	A3	36280	3														
				DECIMALS ANGLES													
				X.XXX ±0.010 ±1/2°													
				X.XX ±0.03													
				X.X ±0.1													



A/C or Part _____
Work Order # 2015-63
Date _____

Approved Manufacturing Facility 73-04 Form 20.F.04 Rev. Original 1 Mar 2013